Work Order ID 90771 *90771* Page 1 September-26-12 10:34:05 AM Item ID: D350-591-312 Accept *N900040100* Setup Start **Revision ID:** Heli-Access-Step, Long RH Item Name: *10* **Start Qty: 10.00 Start Date:** 9/26/12 **Cust Item ID:** Req'd Qty: 10.00 Required Date: 10/19/12 **Customer:** Reference: Start Run Process Plan: MLJ Date: 12-09-26 Tooling: Approvals: Date: Stop QC: _____ Date: ____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description **Run Hours** Code Qty **Qty** Number Stamp Draw Nbr **Revision Nbr** D3272 Rev B 100 0.00 DOCUMENT CONTROL *100* 0.00 Memo Photocopy bluefile and type labels as per PPP D350-591-312 CHG001 Document Control 110 0.00 Large Fab *110* Large Fab 0.00 Memo Large Fab 1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per @SI 004 & Dwg D3272

A/R Aluminum Rod <u>M 12235</u>2 M 122431

3-Grind End Plate flush

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VVOIR OIG	e ₁					Rework]		Skid-tube	Crosstube] '	Water Jet		Engineering
Part I	No.					Scrap		•	Machining	Small Fab	Pro	od. Eng. Coor.	-	Quality
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	! f	Ripples in	Bend			Drill Holes	1	Offset						

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

Work Order ID 90771 *90771* Page 2 September-26-12 10:34:05 AM Item ID: D350-591-312 Accept *N900040100* Setup Start **Revision ID:** Item Name: Heli-Access-Step, Long RH **Start Qty: 10.00 Start Date:** 9/26/12 **Cust Item ID:** Required Date: 10/19/12 Req'd Qty: 10.00 **Customer:** Reference: Run Start Process Plan: Date:____ Tooling: **Approvals:** Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID Description Run Hours** Code Qty Qty Number Stamp 120 QC9- Inspect visual per QSI004- Fusion Welds 0.00 *120* QC 0.00 Memo Quality Control 130 QC5- Inspect part completeness to step on W/O *130* OC Memo Quality Control 140 Chemical Conversion Coat per QSI005 4.1 0.00 *140* HandFinish 0.00 Memo

Hand Finishing

Ac 12 10.10 fl 12 10.10

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Part N	No.					Scrap			Machining	Small Fab	1	Proc	d. Eng. Coor.	-	Quality
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NCR N	No					Work Order Update			Large Fab	Composite			Supplier		
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Ì	He	at Treat	:			Countersink		Mislabe	led		٦p	ositioned W	/rong		
- [Ins	pection	Strip in	Tube		Cut Too Short		Misread	I		Īρ	ower Loss/S	Surge		Other

Offset

Out of Calibration

Outside Dimensions

Out of Sequence

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Work Order ID 90771 *90771* Page 3 September-26-12 10:34:05 AM Item ID: D350-591-312 Accept *N900040100* Setup Start **Revision ID:** Stop Heli-Access-Step, Long RH Item Name: *10* **Start Date:** 9/26/12 **Start Qty: 10.00 Cust Item ID:** Required Date: 10/19/12 Req'd Qty: 10.00 **Customer:** Reference: Start Run Process Plan: Date: **Tooling: Approvals:** Date: Stop QC: _____ Date: ____ SPC (Y/N): , 3, Date: Sequence ID/ Set Up/ Tool ID Reject Operation Tool # Plan Accept Reject Insp. **Work Center ID Description Run Hours** Code Otv Otv Number Stamp QC3- Inspect Part Finish 0.00 QC 0.00 Memo Quality Control 180 0.00 Large Fab *120* Large Fab 0.00 Memo Large Fab 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/RAluminum Rod 122358

6-Grind End Plate flush

7-Install last rivet as per Dwg.

NCR:	Ves	7)	No
NCR:	Yes	7)	No

WORK ORDER NON-CONFORMANCE / UPDATE

1-1	*	*
DOA: A Date: /	17/16/27	
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QA Closed: / Date:	((

Work Ord	er: <u>9</u> (011	7/		DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
					Rework		Skid-tube	Crosstube		Water Jet	Engineering
Part f	No. <u>D35</u> No. <u>12</u>	0-59	11-3	3)2	Scrap		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
				<u>·</u>	Use-as-is	The	rmoforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	Vo. 12	-19-	18		Work Order Update		Large Fab	Composite		Supplier	
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Cause	Date	Step	Qty	(or Non-conformance	Chief En	g Desc	ription	Date	Verification	n QC Inspector
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Operator				a7 x1	Stop NASA William	200	+ Remore Oh	•	12:10:16	12/0/25	
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Other	1/10/16		5100	1,000				chirs + Albers	10.16		
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Supplier									12 10:16		
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Unapproved	L L			<u> </u>		=	m = 12/44	<u> </u>	12.1016	(011.103	
						ULT CAT	EGORY				
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F	Bending			_	Bend	Grain		 	Ovalized		Pressure/Forced
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	Cracks	- · ·		<u> </u>	Broken/Damaged	——————————————————————————————————————	ction Incomplete		Part Incorre	i	Weld
	Crushed/0	Crimped.			Burrs		ctions Incomplete/	Unclear	Part Lost/M	issing [Wrong Stock Pulled
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	Ripples in			_	Drill Holes	Offse			4.1	snot full;	r cleaned out
	Torque W		xtrusio	n	Drawing	_	f Calibration		correctly.		
	Turning Se	•			Finish		f Sequence				
1	Wave/Tw	ist in Tub	e		Folio	Outsi	de Dimensions				

Work Order ID 90771 *90771* Page 4 September-26-12 10:34:05 AM Item ID: D350-591-312 Accept *N900040100* Setup Start **Revision ID:** Heli-Access-Step, Long RH **Item Name:** 9/26/12 **Start Qty: 10.00 Start Date: Cust Item ID:** Required Date: 10/19/12 Req'd Qty: 10.00 **Customer:** Reference: Run Process Plan: ______ Date:_____ Approvals: **Tooling:** Date: Stop Date:_____ SPC (Y/N): Date: Sequence ID/ Operation Tool ID Reject Insp. Set Up/ Tool # Plan Accept Reject **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp 190 QC10- Inspect visual per OSI004- ground welds *190* Memo Quality Control ... 200 QC5- Inspect part completeness to step on W/O Memo Quality Control 210 Chemical Conversion Coat per QSI005 4.1 0.00 10 1h 12-10-17

0.00

Memo

HandFinish

Hand Finishing

NCR:	Yes	/ No				WORK ORDER NON-	CO	NFORI	MANCE / UPDATE					
											QA Closed:	Dat	e:	
Work Ord	er: _					DISPOSITION	_		AGAINS	T DE	PARTMENT,	PROCESS		
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Out of Sequence

Outside Dimensions

__,Date: ____

DQA:

Turning Sequence

Wave/Twist in Tube

Finish Folio

Work Order ID 90771 *90771* Page 5 September-26-12 10:34:05 AM Item ID: D350-591-312 Accept *N900040100* Setup Start **Revision ID:** Item Name: Heli-Access-Step, Long RH **Start Date:** 9/26/12 **Start Oty:** 10.00 **Cust Item ID:** Required Date: 10/19/12 Req'd Oty: 10.00 **Customer:** Reference: Run Process Plan: **Approvals:** Date: **Tooling:** Date: Stop ____ Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. **Work Center ID Description** Qty Qty Stamp Code Number **Run Hours** 220 White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum 0.00 *220* Powdercoat Powder Coating m121878 FINISH TIME: 45 Wing Walk as per dwg QS1005 4.4 Batch 230 10pt # 10108. *230* HandFinish 0.00 Memo Hand Finishing 240 QC3- Inspect Part Finish 0.00 10 Rt & Al w/10/18 0.00 Memo

Quality Control

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NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPI	DATE				
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Work Ord	CI.					Rework	7		Skid-tube	Crosstube	¬ .	Water Je	et	Engineering
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						Use-as-is]	Therm	noforming	Finishing	Rec/St	tore/Packagin	g	Other
NCR I	No.					Work Order Update			Large Fab	Composite]	Supplie	er	
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		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incor	rect		Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/l	Jnclear	Part Lost/	Missing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Move	ed		
1		Heat Trea	t			Countersink		Mislabe	led		Positione	d Wrong		_
!		Inspection	n Strip in	Tube		Cut Too Short		Misread	l		Power Los	ss/Surge		Other
•		Ripples in	Bend			Drill Holes		Offset						

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Work Ord				*907	771*							Page 6	==
Item ID: Revision ID: Item Name:	D350-591-3	Step, Long RH		Accept	*N900	040	100)*	-	art op	*N:	S1*	<u> </u>
Start Date: Required Date: Reference:	9/26/12	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item Customer:	ID:				•	"INI	S2*	
Approvals:		an:		- 0 -		ate:			Run Sta St	art op	*NI *NI	R1* R2*	
Sequence ID/ Work Center II	D	Operation Description Pick Kit		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty		eject umber	Insp. Stamp	_
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*260 *260*		QC4-100% Inspect kits for	or completeness	0.00 QA	1,7/10/27			+60					
Quality Control		Memo		0.00 9 ~ 5	•			RM				÷	
270 * 27 0*		Packaging		0.00							lä	40/24	s l
Packaging Packaging		Memo Identify and p Location:	pack for shipping as per P	0.00 PPD350-591-312								71010-7	7

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Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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Work Orde September-26-1				*907	771*							Page	7
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Start Date: Required Date: Reference:	9/26/12	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item I Customer:	D:				•	"IVI	S2*	
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	1/1	R1* R2*	
Sequence ID/ Work Center II 280	D	Operation Description QC21- Final Inspection	Work Order Release	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Re Qt	•	Reject Number	Insp. Stamp	-
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Quality Control

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Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verific	ation	QC Inspector
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		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Inco	rrect		Weld
		Crushed/	Crimped,			Burrs		Instruct	ions Incomplete/	'Unclear	Part Lost	/Missing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance		Part Mov	ed		
		Heat Trea	t			Countersink		Mislabe	led		Positione	d Wrong	·	-
		Inspection	n Strip in	Tube		Cut Too Short		Misread	i		Power Lo	ss/Surge		Other
		Ripples in	Bend			Drill Holes		Offset						

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Page 1

Work Order ID:

90771

Parent Item:

D350-591-312

Parent Item Name:

Heli-Access-Step, Long RH

Start Date: 9/26/12

Required Date: 10/19/12

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3572-1

JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:eC

IPP Rev:D fixe route seq in bom DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1		Manufactured	No			110	Each	35.0000	1	10			
Step											te_	12.	10.02
				Location	_	Loc Qty	<u>Lo</u>	c Code		_			
				WA BC	10708 -	→ 35			(10	2			
•				8968	33	10					,		
				8968		10							
				8968	35	5				 	11		
D3067-1 End Plate		Manufactured	No			110	Each	56.0000	1	10	16/	2.10	·05
				Location		Loc Oty	<u>Lo</u>	c Code					
				WA B90	178	52			/	0			
				7860		4							
				8385		1							
				8692		45							
				8783	32	2					•		
				WA016		4							
				6758		2							
				6821 7960		1							
D3219-1 Plate		Manufactured	No	7500	•	110	Each	170.0000	2	20	M	, 2.10. (<u> </u>
				Location		Loc Qty	Lo	c Code					
				WA		152			\mathcal{A}	20			
				8385	2	92				_			
				8888	8	60				<u>_</u>			
				WA016		18							
				7341		12							
				7767	4	6							

NCR:	Yes	/ No-			•	WORK ORD	ER NON-C	10:	NFORM	MANCE / U	PDATE					
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Work Ord	er:					DISPOS	SITION				AGAIN	IST DE	PARTMENT	/PROCESS		
Part NCR						Work Orde	Rework Scrap Use-as-is r Update		t Therm	Skid-tube Machining noforming Large Fab	Crosstu Small F Finish Compos	ab ing		Water Je d. Eng. Coor re/Packaging Supplie		Engineering Quality Other
Root					Descri	ption of work ord	er update		nitial	Д	ction		Sign &			
Cause		Date	Step	Qty	C	or Non-conforma	nce	Ch	ief Eng	Des	scription		Date	Verification	on	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved			,						•							
							F.A	\UL	T CATE	GORY						·· · · · · · · · · · · · · · · · · · ·
Landi		I			ν, ,	General			1				1			/5
	-	Bending Centre No	t Concer	ntric to C	o/s	Bend BOM/Route		┈	Grain Hardwa	re	•		Ovalized Over/Under	tolerance		Pressure/Forced Temperature/Cure
		Cracks				Broken/Damage	d		Inspecti	on Incomplete			Part Incorre	ct	\vdash	Weld
	_	Crushed/0	Crimped,			Burrs		-	ĺ	ions Incomplete	e/Unclear	<u> </u>	Part Lost/Mi	issing		Wrong Stock Pulled
		Cuffs				Contamination		Ш	Mainte	nance			Part Moved			
	Ш	Heat Trea	t			Countersink		Ш	Mislabe	led			Positioned V	-		1
		Inspection	Strip in	Tube		Cut Too Short			Misread			L	Power Loss/	Surge		Other
		Ripples in	Bend			Drill Holes			Offset							
		Torque W	aves in E	xtrusion		Drawing	:		Out of C	alibration						

Out of Sequence

Outside Dimensions

DQA:

,Date: ,

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

September-26-12 10:34:04 AM

Work Order ID: 90771 Parent Item: D350-591-312 Required Date: 10/19/12 **Start Date: 9/26/12** Parent Item Name: Heli-Access-Step, Long RH **Start Qty: 10.00** Required Qty: 10.00 D3066-1 No 180 Each 75.0000 Manufactured 2 20 Spacer Loc Oty Location Loc Code 890211 75 15 89399 60 1/12.10.15 MS20600-AD4W4 Purchased No 180 Each 160 2,746.0000 Rivets Location Loc Qty Loc Code 321 18 121652 18 ST311 1000 123021 1000 ST321 1728 121011 121340 39 1680 121444 1/12.10.15 D3065-041 180 Manufactured No Each 11.0000 Step Leg Assembly Hi Loc Qty Location Loc Code 38827 10 ST -20 85083 10 WA 66149 79336 WA013 30

											DQA	,Date	e: <u>, </u>
NCR:	Yes	/ No				WORK ORDER NON-	CO	NFORM	MANCE / UPI	DATE			
									<u></u>		QA Closed	: Dat	e:
Work Ord	lor.					DISPOSITION				AGAINST DI	EPARTMENT	PROCESS	
Work Old	CI.					Rework	7		Skid-tube	Crosstube	٦	Water Jet	Engineering
Part I	No.					Scrap	1		Machining	Small Fab	Pro	od. Eng. Coor.	Quality
						Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	No.					Work Order Update	date Large Fab Composite Supplier						
Root					Descri	ption of work order update		Initial	Act	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Cł	nief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling	Ш												4
Operator													
Material												1	
Setup	Ц												
Other	Ш												
Process	Ш												
Supplier	Ш												
Training	Ш			.									
Unapproved												<u></u>	
							AUI	LT CATE	GORY				
Landi	_)				General	_	7		_	٦ .	Г	
	\vdash	Bending			ļ	Bend	_	Grain		-	Ovalized		Pressure/Forced
	-	Centre No	ot Concer	ntric to (D/S	BOM/Route	<u></u>	Hardwa		<u></u>	Over/Unde		Temperature/Cure
	-	Cracks				Broken/Damaged	_	4	on Incomplete	_	Part Incorre	-	Weld
	\vdash	Crushed/	Crimped,			Burrs		-1	ions Incomplete/l	Jnclear	Part Lost/N		Wrong Stock Pulled
		Cuffs				Contamination	_	Mainte		<u> </u>	Part Moved		
	-	Heat Trea				Countersink	<u></u>	Mislabe			Positioned		
	-	Inspection		Tube	<u> </u>	Cut Too Short	_	Misread			Power Loss	/Surge	Other
	ll	Ripples in	Bend			Drill Holes	1	Offset					

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio September-26-12 10:34:05 AM

Work Order ID:	90771										
Parent Item:	D350-591-312						Star	t Date: 9/26/12		Required Date:	10/19/12
Parent Item Name:	Heli-Access-Step, I	ong RH					Star	rt Qty: 10.00		Required Qty:	10.00
D3067-1 End Plate		Manufactured	No		180	Each	56.0000	1	10	12/2.	10-15
				Location	Loc Oty		Loc Code				
				WA <u>B9017</u>	Z 52						
				78608 83855	4						
				86923	45						
				87832	2						
				WA016	4						
				67582	2						
				68214	1						
AN3-35A		D 1 1	No	79607	250	Each	94.0000			./	
Bolt		Purchased	190		. 230	Еасп	94.0000	2 _/233	20 3 5 2	18	0/
				Location	Loc Qty		Loc Code			0	
				FG	10						
				122800	. 10						
				ST353	84						
				122800	84			- <u></u>			
O3235-1 Mounting Lug		Manufactured	No		250	Each	56.0000	900	o 20	10	B
				Location	Loc Qty		Loc Code				
				ST471	50						
				88262	50						
				ST481	6						
				83853	6						
D3278-041 Support Assembly		Manufactured	No		250	Each	63.0000	1	10	-1B	12116/1
				Location	Loc Qty		Loc Code	27899	774	1	
				ST470	40		<u> </u>	0.707	, , ,		>
				89106	40			8 × 89/1	56	_	`
				ST481	23			<u> </u>			
				83858	23						

											DQA:	Date	
NCR:	Yes	/ No				WORK ORDER NON-O	COI	NFORI	MANCE / UF	PDATE	0.00	Data	
							-				QA Closed:	Date	
Work Ord	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
			,			Rework			Skid-tube	Crosstube]	Water Jet	Engineering
Part	Νŏ.					Scrap			Machining	Small Fab	-	d. Eng. Coor.	Quality
		•			٠	Use-as-is		•	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR	No.				·····	Work Order Update]		Large Fab	Composite]	Supplier	
Root					Descri	ption of work order update	1	Initial		ction	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Des	cription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material	L												
Setup	L												
Other 1													
Process							l						
Supplier							ĺ						1
Training													
Unapproved													
						F.	AUL	T CATE	GORY				
Landi	ng (Gear				General				,	7	-	 1
		Bending				Bend		Grain			Ovalized		Pressure/Forced
	<u></u>	Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved		
		Heat Trea	t			Countersink		Mislabe	led		Positioned \	Nrong	
	Г	Inspection	n Strip in	Tube		Cut Too Short		Misreac	i		Power Loss,	/Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish Folio

September-26-12 10:34:05 AM

Work Order ID:

90771

Parent Item:

D350-591-312

Start Date: 9/26/12

Required Date: 10/19/12

	Parent Item Name:	Heli-Access-Step, L	ong RH						Sta	rt Qty: 10.00		Required Qty:	10.00
S	AN960JD416 Washer	NAS1149D0463J	Purchased	No			250	Each	29.0000	16	160 Ly 52	JB	3
700					Location	<u>n</u>	Loc Oty		Loc Code				
					ST351		29	9					
						116289		8					
	. 210 40 70 71),,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,				119097	2			 		4	å
Suc	AN960JD516 7 Washer	NAS1149D0563J	Purchased	No			250	Each	2.0000	4 /21	255 255	JB	
					Location	<u>1</u>	Loc Oty		Loc Code				
					ST338		:	2					
						1069059		2					
Sat	AN5-36A Bolt		Purchased	No			250	Each	176.0000	2	20	13	12/10/19
1					Location	<u>1</u>	Loc Oty		Loc Code				SL
					ST338		50						(O)
						123021	50			4×1230	221		
					ST340		20	5					
						122141	26	5					
					ST358		100			1.4	ر 		
						122808	100			16×122		_	1
6	D2618 Bushing		Manufactured	No			250	Each	99.0000	2	20	90104	(42/10/22
tho	,				Location	<u>1</u>	Loc Oty		Loc Code			Ţ	(10)
					ST013		99						Ø-2
						76130	2						13
						84646	3						•
						85446	10						
						86844	84	ļ					

											DQA:	_ Dat	e: 🚣	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE				
										·	QA Closed	Dat	e:	
Work Ord	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part						Rework Scrap Use-as-is		1	Skid-tube Machining	Crosstube Small Fab Finishing		Water Jet od. Eng. Coor. re/Packaging		Engineering Quality Other
NCR	No.					Work Order Update		i .	Large Fab	Composite	osite Supplier			
Root					Descri	ption of work order update		Initial	Ac	ction	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification		QC Inspector
Doc/Data														
Equip/Tooling														
Operator														
Material														
Setup									·					
Other													-	
Process													-	
Supplier													1	
Training													ŀ	
Unapproved														
						F.	AUL	T CATE	GORY					
Landi	ng (Gear				General		_		_	_	-		
		Bending				Bend		Grain			Ovalized		'	Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Unde	r tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ect		Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/	/Unclear	Part Lost/M	lissing	'	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved	-		
		Heat Trea	t			Countersink		Mislabe	led		Positioned	Wrong		
•		Inspection	n Strip in	Tube		Cut Too Short		Misread	1		Power Loss	/Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

September-26-12 10:34:05 AM

Work Order ID:	90771										
Parent Item:	D350-591-312							Start	Date: 9/26/12	Required Date:	: 10/19/12
Parent Item Name:	Heli-Access-Step,	Long RH						Start	Qty: 10.00	Required Qty:	
D2230-3		Manufactured	No			250	Each	315.0000	4 4	10 /	
Lug									244 90514	1 JB	
Sino				Location	<u>on</u>	Loc Qty		Loc Code	•	V	
400				FG		4					
					89045	4					
				ST469		311			-		
					88185	48					
					89045	63					
					89782	200			16289782		
D2856-400 Abrasion Strip	i.t	Manufactured	No			250	f	322.3994		2 ~ 1 B	8
Abrasion Strip	see "			Locatio	<u>on</u>	Loc Oty		Loc Code			
6				ST403		218.198					
to bresser)				81875	6.398					
orb Grepson	0/72				89352	211.8					
8121	0(-			ST409		104.2014					
					63735	0.6696					
					68076	0.3149					
					71164	8.46			·- <u>-</u>	/	
					86905	94.7569			86903		
MS21042L3		Purchased	No			250	Each	2,157.0000	17326	5 18	12/10/
				Locatio	<u>on</u>	Loc Oty		Loc Code		V	Q/-
				316		719					
					122452	719					
				ST300		372					
					117885	32					
					119017	202					
					119075	138					
				ST317		1066					
					122141	1066					

										DQA:	,Date:	~
NCR:	Yes /	No			WORK ORDER NON-	COI	NFORI	MANCE / UPDATE			5 /	
_					,			···		QA Closed:	Date:	
Work Ord	or·				DISPOSITION			AGA	AINST DE	PARTMENT	PROCESS	
VVOIROIG	C1.				Rework	7		Skid-tube Cross	stube	I	Water Jet	Engineering
Part	No.				Scrap	1			Il Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	1		~ 	shing	Rec/Stor	e/Packaging	Other
NCR I	No	-			Work Order Update			Large Fab Comp	osite]	Supplier	
Root			T	Descri	ption of work order update	Ţ	Initial	Action		Sign &		
Cause	Da	te Step	Qty	1	or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material					•							
Setup												
Other												
Process												
Supplier												:
Training												
Unapproved												
					F	AUL	T CATE	GORY				*****
Landi	ng Gear				General		•		_	•		7
	Bend	ing			Bend		Grain			Ovalized		Pressure/Forced
	Centr	e Not Conce	entric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Crack				Broken/Damaged		4 '	ion Incomplete	L	Part Incorred	⊢	Weld
	Crush	ed/Crimped	l <u>.</u>		Burrs	L	Instruct	ions Incomplete/Unclear	<u> </u>	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	enance	<u> </u>	Part Moved		
	Heat	Treat			Countersink		Mislabe	eled	1	Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

September-26-12 10:34:05 AM

Work Order ID:

90771

Parent Item:

D350-591-312

Parent Item Name:

Heli-Access-Step, Long RH

Start Date: 9/26/12

Required Date: 10/19/12

Start Qty: 10.00

Required Qty: 10.00

AN4-13A Septimber 135	Purchased	No		250 E	Each 1,576.0000	8	80 - 28	82
7 0			Location	Loc Qty	Loc Code			
			FG	20				
			122808	20				
			ST356	1363		12	2416	
			122416	498				
			122808	365				
			122993	500				
			ST357	193				
			120187	19				
			120770	12				
			121652	161				
			122063	1				
MS21042L5 Nut	Purchased	No		250 E	Each 1,452.0000	2	20 JB	12410/19
20			Location	Loc Qty	Loc Code		_	
			300	356				(A)
			121652	356		12	1657	
			314	1000		•		
			122452	1000				
			ST300	96				
			108827	4				•
			116105	1				
			116548	43				
			119109	36				

12

2937

					•						DQA:	, Date	
NCR:	Yes	/ No				WORK ORDER NON-	CO	NFORM	MANCE / UPI	DATE			
							-				QA Closed:	Date	:
Work Ord	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Ord	CI.					Rework	7	1	Skid-tube	Crosstube	1	Water Jet	Engineering
Part I	No.					Scrap	1	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
,						Use-as-is	1	Therm	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR I	No.					Work Order Update]		Large Fab	Composite	<u>.</u>	Supplier	
Root			T	T	Descri	tion of work order update	T	Initial	Act	ion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	CI	nief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material													
Setup													
Other	Ш												
Process	Ш												
Supplier	Ш												
Training	Ш												
Unapproved			L	<u> </u>				_			<u> </u>		
							AUI	LT CATE	GORY				
Landi		1				General	_	7		_	1	F-	-
	-	Bending			<u> </u>	Bend	<u> </u>	Grain		<u></u>	Ovalized	<u>_</u>	Pressure/Forced
	-	Centre No	ot Conce	ntric to (D/S	BOM/Route	<u> </u>	Hardwa		_	Over/Under	<u> </u>	Temperature/Cure
	\vdash	Cracks			<u> </u>	Broken/Damaged	<u> </u>	-1 '	on Incomplete	<u> </u>	Part Incorre	-	Weld
	-	Crushed/	Crimped.		<u> </u>	Burrs	\vdash	-1	ions Incomplete/l	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	$\vdash \vdash$	Cuffs			<u> </u>	Contamination	\vdash	Mainte			Part Moved		
	-	Heat Trea			<u> </u>	Countersink	\vdash	Mislabe			Positioned V		¬
	-	Inspection		Tube	<u> </u>	Cut Too Short	\vdash	Misread	I		Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes		Offset					

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

Pi	۸l,	1:.	4	D.	.:.	4
М	СK	HIS	П	rı	'IN	L

September-26-12 10:34:05 AM

Work Order ID:

90771

Parent Item:

D350-591-312

NAS1149D0363J

Purchased

No

Parent Item Name:

Heli-Access-Step, Long RH

Start Date: 9/26/12

Required Date: 10/19/12

Start Qty: 10.00

Required Qty: 10.00

314 2738 122452 2738 122452 2738 122452 3738 5T300 27 121444 7 5T314 3000 123021 3000 250 Each 0.0000 4 40 40 4

123248 JB

Page 7

AN960JD10

NCR:	Yes	/ No				WORK ORDER NON-C	OI	NFORM	MANCE / UPD	ATE		·,	
											QA Closed:	Date:	
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part NCR	No.					Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube Vachining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	otion of work order update		Initial	Actio	on	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Descrip	otion	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	ng					,							
							AUL	T CATE	GORY				
Landi	ng Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat					General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink		1 '	on Incomplete ions Incomplete/Un nance	nclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V	ssing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
	1 1	Inspection	Strin in	Tuhe	[Cut Too Short	1	Misread			Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

"Date: -

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



	DESIGN DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHEC	/	APPROVED	DRAWING NO.	REV. B
	E	1	D3272	SHEET 1 OF 3
DATE			TITLE	SCALE
07.0	07.05.18		STEP ASSEMBLY, HI LONG	NTS
Α		04.03.01	NEW ISSUE	
В		07.05.18	D3272-1 WAS D2622-120	

RELEASED 0706.04.

QTY		
-042	PART NUMBER	DESCRIPTION
	D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
Х	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	D3065-041	LEG ASSEMBLY
2	D3066-1	SPACER
2	D3067-1	END PLATE
2	D3219-1	SUPPORT
1	D3272-1	STEP
16	MS20600AD4W4	RIVET
	-042 X 1 2 2 2 1	-042 PART NUMBER D3272-041 X D3272-042 1 D3065-041 2 D3066-1 2 D3067-1 2 D3219-1 1 D3272-1

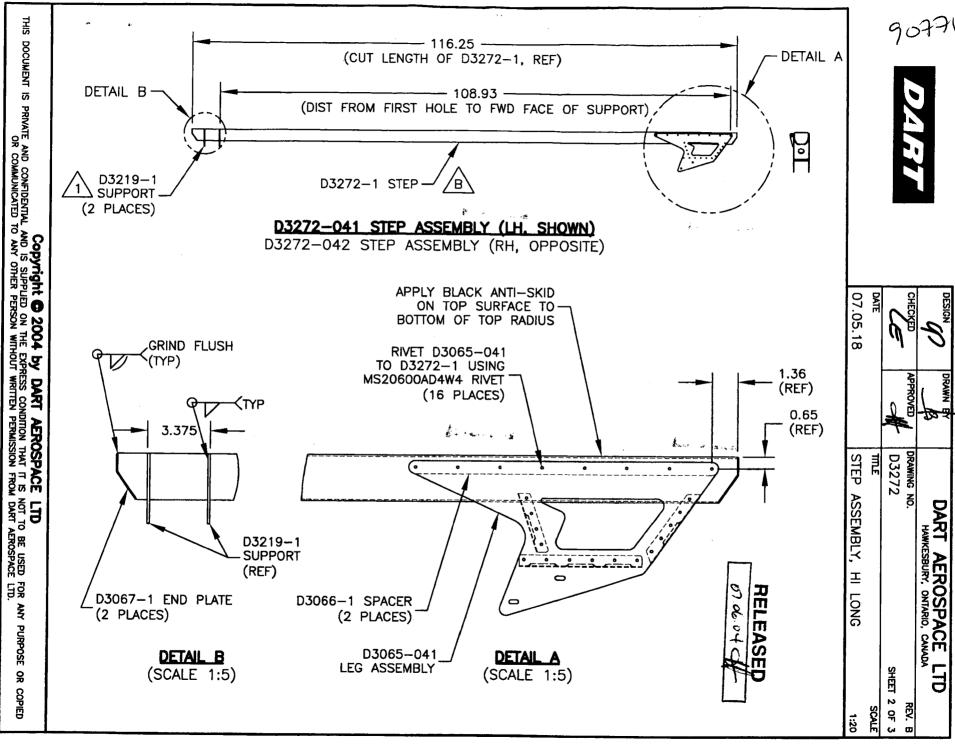
GENERAL NOTES:

- D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- WELD PER DART QSI 004
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

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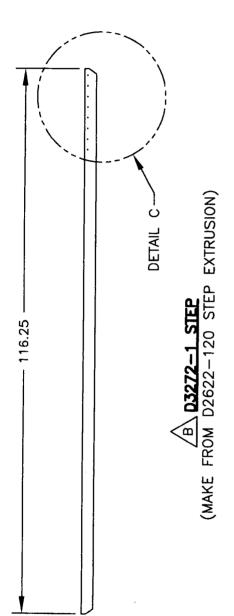
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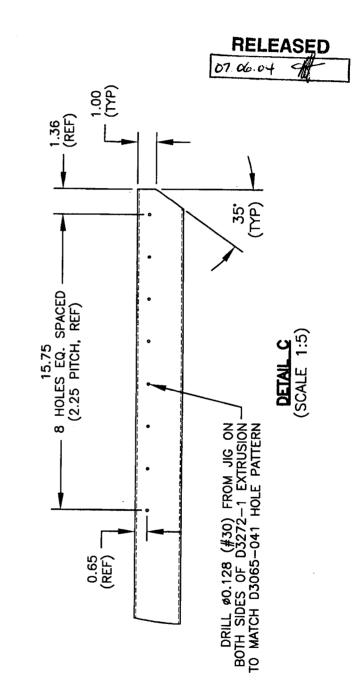






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